

STERLCO TEMPERATURE CONTROL UNIT  
SERVICE AND INSTRUCTION MANUAL  
MODEL S-8312, S-8322, S-8332

Engineered and Manufactured by INDUSTRIAL CONTROL DIVISION  
STERLING, INC.  
5200 West Clinton Avenue, P.O. Box 23435, Milwaukee, Wisconsin 53223-0435  
Manufacturers of Temperature Control Equipment Since 1916

## Please note that our address and phone information has changed. Please reference this page for updated contact information.



These manuals are obsolete and are provided only for their technical information, data and capacities. Portions of these manuals detailing procedures or precautions in the operation, inspection, maintenance and repair of the products may be inadequate, inaccurate, and/or incomplete and shouldn't be relied upon. Please contact the ACS Group for more current information about these manuals and their warnings and precautions.

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The ACS Customer Service Group will provide your company with genuine OEM quality parts manufactured to engineering design specifications, which will maximize your equipment's performance and efficiency. To assist in expediting your phone or fax order, please have the model and serial number of your unit when you contact us. A customer replacement parts list is included in this manual for your convenience. ACS welcomes inquiries on all your parts needs and is dedicated to providing excellent customer service.

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MODEL: S-8300 SERIES

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INTRODUCTION

We are pleased to provide a Water Circulating Temperature Control Unit for your application. It is built by skilled craftsmen with the most modern and precision machines available today. The simplicity of design and compactness engineered into the unit resulted in less maintenance and less floor space.

The Sterl-Tronic High Temperature Control Unit; designed and tested over a period of many years, represents one of the most significant advances ever in the field of self-contained, closed systems - portable units for heating water and circulating it at controlled temperatures - through molds, rolls or jackets of processing equipment.

The Sterl-Tronic temperature control unit is designed to circulate water through your process and to precisely, automatically, and reliably maintain this water at the selected temperature. The operating range of the Sterl-Tronic unit is from supply water temperature up to 250° F. maximum. The unit is well suited for use with a city water supply, water from portable or central chillers, towers or with well water.

Many new improved designed features have been incorporated into the Sterl-Tronic. Among them are: solid-state electronic thermostat, automatic mechanical proportioning of heating and cooling, dual electronic sensing probes, and pushbutton air vent.

The relatively small total amount of water, rapidly recirculated by the Sterl-Tronic, provides assurances of a close and uniform temperature relationship between the delivery and return lines of the unit. This assures uniform and stable temperature control as well as a very even temperature throughout the work area. Also, the high rate of recirculation, combined with the large immersion heater and high cooling rate, gives the unit exceptionally fast response in bringing the process up to temperature and in making changes of settings when necessary.

These standard units may have many variations of optional features added to them, relative to the customer's application of specific desires.

The unit is warranted against defects in materials and workmanship for one year from date of shipment.

Any Sterlco unit which has been used contrary to specific operation instructions or materially altered, will not be covered by this warranty. Final determination of defects must be made at Sterling, Inc.

The units can easily be moved from one location to another, simply by removing the circulating connection lines.

By following the instructions in the manual and treating your equipment with care and respect due any precision equipment, you will be rewarded with years of uninterrupted, trouble free service.

MODEL: S-8300 SERIES

DESCRIPTION

SYSTEM TEMPERATURES

The system temperatures are easily read on the meter which is part of the controller. Its long thin needle with close calibration permits the detection of small temperature variations.

ELECTRICAL

The pump motors and the immersion heaters operate on three phase, full line voltage with the control circuit operating at 115V single phase. The control circuit voltage is provided by a single phase transformer wired across two legs of the three phase power supply. Magnetic motor starters with overload and high/low voltage protection are used for the pump motors. The 115V control circuit is fused.

NOTE:

ALL PUMP MOTORS ARE THREE (3) PHASE AND PUMP ROTATION MUST BE CHECKED TO INSURE PROPER OPERATION OF YOUR UNIT.

VENT PUSHBUTTON

This pushbutton permits a quick and complete purge of air from the operators panel, before the unit is started. The "VENT" pushbutton actuates the solenoid valve which permits the flow of trapped air and water out through the drain, insuring that the unit is properly filled and primed prior to start-up.

PRESSURE SWITCH

The Pressure Switch is built into each unit to insure that the unit will not start until the water supply has been turned "ON" and the unit subjected to water supply pressure. This is intended to provide a strong measure of protection for the pump seal and the heater so that they will not be damaged through operation without water. The final measure of protection must come from the operator in venting before start-up. The pressure switch itself is set at approximately 10 PSI prior to leaving Sterling.

MODEL: S-8300 SERIES

CIRCULATION

PUMP

The pump is a straight centrifugal type, bronze-fitted. It has a high output capacity with good discharge pressure and is well suited for the conditions under which the unit is designed to operate. The circulating capacity available to the user, outside the unit, is as stated below.

NOTE:

ALL PUMP MOTORS ARE THREE (3) PHASE AND PUMP ROTATION MUST BE CHECKED TO INSURE PROPER OPERATION OF YOUR UNIT.

A special seal-flush system in the pump helps keep the seal clean, thereby extending seal life. The seal itself is the finest type available for this type of service and provides an excellent combination of long wearing ability, high abrasion resistance and heat resistance. For pump (only) ratings, please refer to page 4 of Bulletin #844. The following table is a listing of true unit capacities.

1/2 H.P.	15 GPM @ 20 PSI
3/4 H.P.	20 GPM @ 20 PSI
1 H.P.	30 GPM @ 25 PSI
1-1/2 H.P.	40 GPM @ 30 PSI
2 H.P.	50 GPM @ 30 PSI
3 H.P.	45 GPM @ 40 PSI
5 H.P.	60 GPM @ 50 PSI

COOLING

Cooling is accomplished by the automatic release of cooling water through the shell of the specially designed shell and tube heat exchanger in each zone. The process fluid, i.e. water, glycol or other similar fluid is circulated through the tubes of the heat exchanger. Naturally, the plant water supply temperature will govern the minimum operating temperature of the unit.

INSTALLATIONELECTRICAL:

These units are supplied for three phase operation for a selected voltage. Caution must be taken to provide a correctly sized power supply to the unit. Refer to unit nameplate for proper voltage and amperage requirements. These units must be securely grounded. Electrical connections and service should only be made with the power disconnected, and only by a qualified electrician.

WATER SUPPLY

It is very important that the water supply to the unit meets certain requirements. We recommend a full sized line, equal to the pipe size of our water supply connection and without restricting fittings. Usable pressure should be in excess of 20 PSI (1.4 KG/CM<sup>2</sup>) and preferably 25 PSI (1.75 KG/CM<sup>2</sup>) at the unit, if the unit is expected to operate at temperatures up to 250° F. If your unit has a maximum operating temperature of 300° F. the water pressure must be maintained at 65 PSI (4.57 kg/cm<sup>2</sup>) or above. This minimum pressure is necessary to keep the process water from flashing to steam at the pump inlet, where pressure is the lowest in the system. The pressure switch inside the unit will keep the unit from running until the unit has been subjected to a minimum water supply pressure.

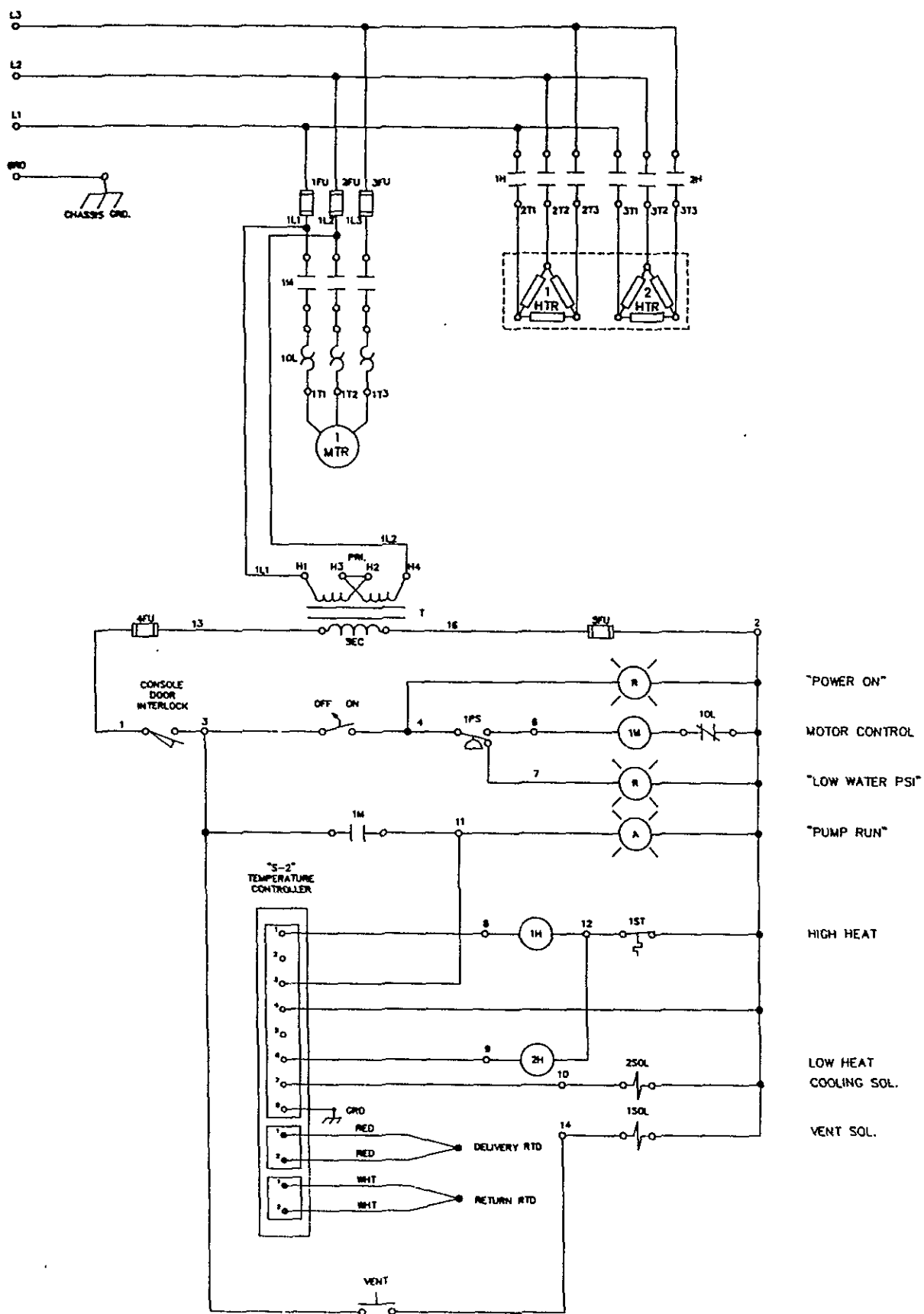
The water supply line should be open to the unit whenever the unit is running. While a certain minimum supply pressure is necessary as stated above, supply pressures over 75 PSI (5.27 KG/CM<sup>2</sup>) while serving no useful purpose may indeed cause damage to the unit and shorten its life. If your water pressure is excessively high, it is recommended that a pressure regulator be installed in the supply line with a relief valve downstream from the regulator and set slightly higher than the regulator. Hard or corrosive water can be damaging to the unit and your equipment, especially since the temperatures at which the system operates tend to accelerate deposits or corrosion. Also, bad water can build layers of scale or lime on the surfaces of the unit, slowing down water flow and causing control problems and eventual damage to the equipment. Since the corrective maintenance and downtime often caused by bad water are costly, it is well worthwhile to treat that water. In general, we have found that people with good water seldom buy parts. Industrial water treatment to neutralize these conditions is relatively inexpensive and in many cases is truly a wise investment.

PROCESS CONNECTIONS:

Connection lines and connectors between the Temperature Control Unit and the process should be selected by the customer to suit the needs and requirements of the application.

- 1) If your unit has a maximum operating temperature of 250° F., the connection lines and connectors should have a service rating of at least 250° F. and 150 PSIG.
- 2) If your unit has a maximum operating temperature of 300° F., the connection lines and connectors should have a service rating of at least 300° F. and 150 PSIG.

These connection lines and connectors should be inspected frequently to ensure that the original service rating has not been reduced by age and/or deterioration.





OPERATION

The simplicity of design and the highly engineered controller make these units almost self-operated.

The "ON-OFF" control, the "VENT" button and the "TEMPERATURE CONTROLLER" are all that is required to operate these units.

After the water supply has been connected up to the "WATER SUPPLY LINE", (the pressure must be in excess of 20 PSI and preferably over 25 PSI, but not to exceed 75 PSI) press the "VENT" button and hold for at least one minute. The solenoid valve opens electrically.

As the water comes in on the water supply line, and as the check valve is closed, the water must enter the pump, go down through the bottom of the tank, up through the tank and out through the "DELIVERY LINE"; through the process, back through the "RETURN LINE", and through the open solenoid valve and out the "DRAIN LINE".

At this time, watching the drain for bubbles or erratic flow will indicate whether or not the system has been properly "purged". If a steady stream flows from the drain line, it is certain that all the air is out of the system.

"OFF-ON" SWITCH

"On Position"

When the switch is in the "START" position, the starter is energized and supplies the power to the motor and the temperature controller, which in turn regulates either "heating or cooling".

NOTE: ALL PUMP MOTORS ARE THREE (3) PHASE AND PUMP ROTATION MUST BE CHECKED TO INSURE PROPER OPERATION OF YOUR UNIT.

"Off Position"

When the switch is in the "STOP" position, the starter is de-energized, cutting the voltage to the motor and the temperature controller.

Set the "SET-POINT" on the temperature controller to the desired heat.

Select half or full heat with the HEAT SELECTOR SWITCH.

As the unit is in the heating cycle, the HEAT INDICATOR LIGHT will illuminate. If the heat of the water travels above the set point, the unit will automatically switch to the cooling cycle and the COOL INDICATOR LIGHT will illuminate.

MODEL: S-8300 SERIES

SHUTDOWN

Prior to shutdown, the water supply to the unit should be shut off.

Depress the "VENT" button for a few seconds to relieve the internal pressure. Water supply and drain lines, delivery and return lines, and the electrical supply may then be disconnected.

DRAINING

If your Sterl-Tronic is to be taken out of service for a long time, or if it will be exposed to freezing, it should be thoroughly drained. Drain plugs are provided at the base of the heater tank, and water supply and drain lines.

OPERATION OF ONE ZONE ONLY OF DUAL OR TRIPLE ZONE UNIT:

When one zone of a dual or triple zone unit is to be operated while the other remains idle, it is necessary to run a by-pass line from the delivery to the return line of the idle zone.

PREVENTATIVE MAINTENANCE:

EVERY SIX (6) MONTHS: DISCONNECT ALL POWER PRIOR TO SERVICING.

Inspect all electrical connections for secure attachment and for safe and secure ground connections. Inspect the power cable, especially at entrance point to the unit. This inspection should be made by a qualified electrician!

## MODEL: S-8000 SERIES

### ALL ELECTRICAL TROUBLESHOOTING MUST BE DONE BY A QUALIFIED ELECTRICIAN

#### TROUBLESHOOTING

##### TEMPERATURE FLUCTUATIONS     Alternate Overheating and Overcooling.

While the user might be inclined to believe the trouble to be in the controller, this fluctuation can most always be traced to poor water flow, resulting from one or more of the following conditions.

1. Small connectors or small water passages. Slow water flow will create a long reaction time which causes overheating and overcooling.
2. Very long connecting lines or long serpentine flow of water in and out of the mold in series rather than in parallel. Refer to the page on installation.
3. Blocked water line in the mold. New molds sometimes contain metal chips or other foreign particles inside the water lines. Old molds sometimes contain lime or rust accumulations.
4. Quick disconnect fitting with check valves. (A source of very serious obstruction.) The check valves should be removed.
5. Lime buildup in the piping or fittings.

NOTE: The unit itself can be checked out for normal control by the use of a short 3/4" or 1/2" line connected directly from the delivery to the return line. This will provide a condition of very good flow and will establish whether the blockage is in the unit or the piping. This connection line should meet all the requirements of the "Process Connections" stated earlier.

##### RAPID CYCLING FROM HEAT TO COOL

This condition is traceable to the same causes as the temperature fluctuations indicated above.

##### UNABLE TO HEAT PROPERLY

When the temperature will not rise above a certain temperature, the cause will generally be traced to continuous loss of water from the system (allowing cooling water to enter). This can be checked by observing the drain. Under some conditions it is possible to have the solenoid valve close on a particle of grit which, of course, will allow the valve to continuously leak. This solenoid valve can be flushed out easily by having the operator adjust the "set point" up and down scale several times to open and close the solenoid. If it continues to leak, the unit should be stopped and the electric power and water turned off and the solenoid valve should be taken apart and cleaned or replaced, as required.

Another cause would be traceable to a leaking connection or fitting somewhere in the system. It is also possible that the immersion heater might be inoperative or defective. Most any qualified electrician can check this out readily. Heater terminals are readily accessible for checking.

HEATER BURN OUT

A direct visual indication of heater burn out is the presence of scorched or discolored paint on the heater tank. In most cases, the water level inside the tank at the time of burn out can be determined because the paint on the exterior of the tank below the water level will not be scorched. Causes of heater burn out are generally traceable to:

1. The unit not being filled with water and purged of air prior to start-up.
2. A faulty heater (tank discoloration not always present).
3. A plugged system or badly obstructed flow.

PUMPS AND SEALS

Before leaving our factory, each unit is operated for a considerable period of time and calibrated. After this test, the unit is drained and blown out with warm air to remove most of the water from the piping systems. If the unit is allowed to stand idle for a long time before being installed in your factory, the housing gasket at the pump can dry out and will possibly leak when the unit is started. In many cases these gaskets will soon swell and form a tight seal, while in other cases it may be necessary for you to tighten the pump screws to stop a leaking condition.

It is possible to have the pump seal surface separate slightly because of rough handling or considerable vibration during transit from our plant to yours. This, of course, would cause a leak at the pump seal when the pump is started, but in most cases the surface will mate again after the pump is allowed to run for short periods of time. If they do not mate, you might find it necessary to open the pump and free the seal by hand. It is seldom necessary to install a replacement seal in a new unit unless the seal has been damaged because the unit has been started without water.

Our pump seals should give a long period of service life. There are conditions, of course, which tend to shorten the seal life - such as presence of grit, operation of the unit without water, sustained high water temperatures or the presence of certain chemicals in the water. Our pump seal assembly has been developed to resist abrasive particles which we find present in many water systems. It is also fitted with high temperature flexible components for a maximum amount of heat resistance. These same components remain flexible even at low temperatures. Thus, the standard seal has a fine combination of heat resistance and wear resistance.

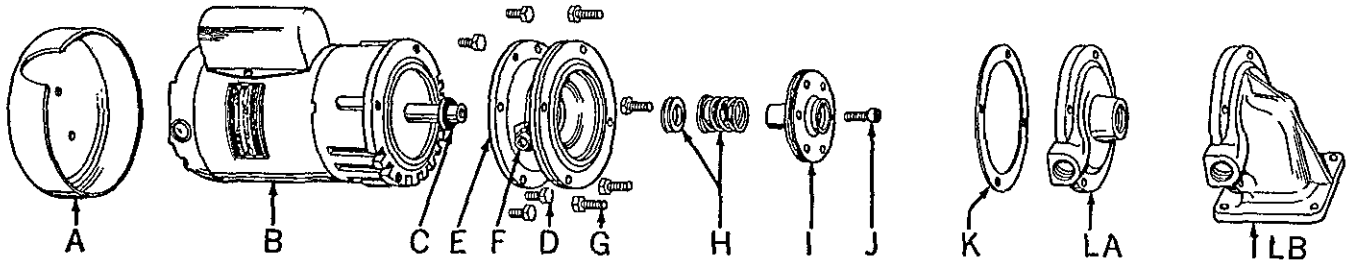
# REPLACING ROTARY SEAL ASSEMBLY ON STERLCO PUMP AND MOTOR

## PARTS

**A. Drip Cover**  
**B. Motor**  
**C. Water Slinger**  
**D. Motor Screws**

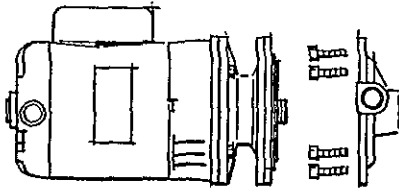
**E. Bracket**  
**F. Prime Cock**  
**G. Pump Screws**  
**H. Rotary Seal Assembly**

**I. Impeller**  
**J. Impeller Screw**  
**K. Housing Gasket**  
**L. Volute - A or B**

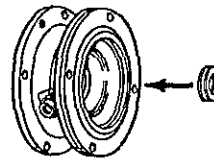


Step No. 1 — Dis-assembling (Removal of old seal assembly)

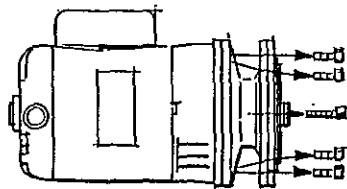
Step No. 2 — Re-assembly (Installation of new seal assembly)



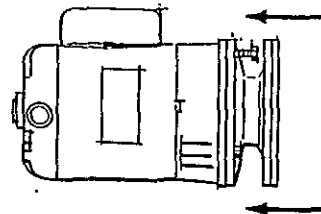
a) Remove volute from motor bracket and impeller assembly by removing pump screws.



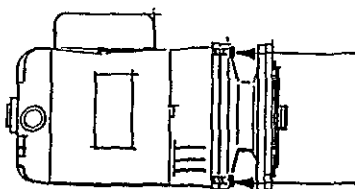
f) Coat outside edge of new seat with 3% detergent solution and slip it into the bracket. Press into bracket with thumbs or wooden dowel. Handle seat carefully so seating surfaces are not scratched or chipped . . . be sure it is squarely seated.



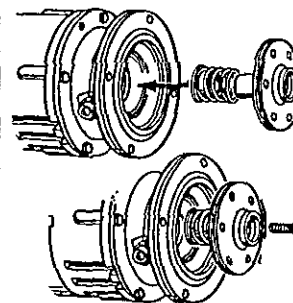
b) Remove impeller screw and motor screws. (Note: opposite end of motor shaft is fitted with screw driver slot to hold shaft securely while impeller screw is being removed. Drip cover must be removed to get at screw-driver slot).



g) Remount bracket on motor.

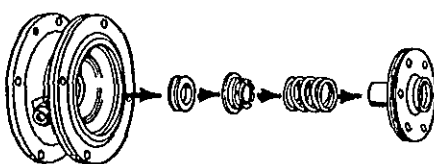


c) Insert two of the pump screws into the two threaded holes in the bracket. Tighten them slowly and evenly to force the impeller and bracket off the shaft. Do not pry the impeller or bracket!



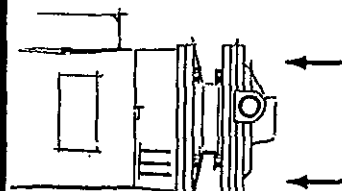
h) Lubricate impeller hub with 3% detergent solution . . . slip new bellows and spring onto impeller hub. Be sure bellows slides freely on impeller hub.

i) Replace impeller on motor shaft extension and secure with impeller screw. Hold shaft with screw driver slot while tightening screw.



d) Remove old seal parts from impeller hub and bracket. Be sure water slinger is in place.

e) Clean impeller hub thoroughly . . . remove all loose particles of dirt, grease, etc. Use fine emery cloth if necessary. Also clean the recess in the bracket so the new seat will fit perfectly. Remove all particles and dirt on gasket surfaces of the two castings.



j) Replace volute onto bracket, using new housing gasket. Use one gasket for condensate pump and for temperature control units. Secure with pump screws. Be certain gasket is seated properly.

**NOTE:** When ordering parts please indicate pump model number and serial number.

**STERLING, INC.** 5200 W. Clinton Ave., Milwaukee, Wisconsin 53223

STERLING, INC.  
PARTS LIST A & C  
STERLCO PUMP 1/2 & 3/4 HP

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
C	542-10404-00	Water Slinger
E	615-13341-01	Bracket
H	081-00024	Rotary Seal Assembly
I	695-18409-00	Impeller, Standard Brass, 1/2 HP
I	695-18409-03	Impeller, Standard Brass, 3/4 HP
J	001-06850	Impeller Screw
K	545-00001	Housing Gasket
LA	615-14921-00	Volute
LB	614-14951-00	Housing
B	720-09170	Motor 1/2 HP 3/60/230-460V TEFC
B	720-09167	Motor 1/2 HP 3/60/230-460V Open
B	720-09168	Motor 3/4 HP 3/60/230-460V Open
B	720-09190	Motor 3/4 HP 3/60/230-460V TEFC

MOTOR, IMPELLER, SEAL ASSEMBLY

695-00007-03	1/2 HP 3/60/230-460V Open
695-00007-24	1/2 HP 3/60/230-460V TEFC
695-00030-03	3/4 HP 3/60/230-460V Open
695-00030-10	3/4 HP 3/60/230-460V TEFC

Sterling part numbers apply to non-special motors. Consult Parts List in your unit manual for specific motor requirements.

March 9, 1983

MODELS: S-8412, 8422, 8432 (A)  
S-8312, 8322, 8332 (A)

<u>PART NO.</u>	<u>DESCRIPTION</u>
729-00084	Contactor, 30 amp.
601-00271	Controller "S-2"
725-00600	Fuse, Control #FNM 1.6 amp @ 250V
725-00558	Fuse, Motor #FRS 1.6 amp @ 600V
106-00011	Heat Exchanger 3.7 Sq. Ft. (S-8300)
722-00108-01	Immersion Heater 9 KW @ 480V
722-00108-02	Immersion Heater 9 KW @ 240V
715-10037	Pilot Light (Red - "Power-On")
715-10036	Pilot Light (Amber - "Pump-Run")
692-07369-01	Probe, Sensing (Heat or Cool)
732-00024	Solenoid Valve w/coil 1/4" 115V coil
162-00001-18	Solenoid Coil only 115V coil
732-00072	Solenoid Valve w/coil 1/2" 115V coil (S-8300)
162-00001-06	Solenoid Coil only 115V coil
726-00005-02	Starter, Motor
632-02858	Switch, Pressure
717-00028	Switch, Micro
717-10027	Switch, Selector (On-Off)
717-10028	Switch, Selector (Vent)
724-00206	Thermostat, Safety
704-00052	Transformer 150VA (230-460V)
044-00138	Valve, Safety Relief 3/4"
720-09167	Motor 1/2 HP 3/60/230-460V
605-00030-11	Complete Pump & Motor Assembly 1/2 HP 3/60/230-460V
695-00007-03	Motor, Impeller, Seal Assembly 1/2 HP 3/60/230-460V
081-00024	Rotary Seal Assembly
545-00001	Housing Gasket
542-10404-00	Water Slinger
001-00850	Impeller Screw
615-13341-01	Bracket E, per Form I-4100-E1
615-14921-00	Volute A, per Form I-4100-E1
695-18409-00	Impeller, Standard Brass

NOTE: Please give Model & Serial No's. when ordering parts. Part No's. are listed as a guide, but many units have special parts or features not covered by this list. Prices are subject to change without notice. Net 30 days, F.O.B. Milwaukee, Wisconsin

STERLING, INC., 5200 W. Clinton Avenue, Milwaukee, Wisconsin 53223-0435  
Phone: (414) 354-0970 Telex 2-6805